

# Work Order ID 47824B

June 26, 2009 8:17:59 AM



Page 1

Item ID: D3327-041  
Revision ID: B  
Item Name: Basket Lid Assembly

Accept



Setup Start



Stop



Start Date: 15/07/2009 Start Qty: 1.00



Required Date: 03/08/2009 Req'd Qty: 1.00



Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3327

Rev B

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1-Cut tubes as per Dwg D3327: Qty Part Number Description  
Batch: 2D3328-1 Hinge Plate 109127 2D3349-1 Spacer  
Bushing 109127 1D3352-1 Label Plate  
109127 2D3367-1 Mounting Bracket 109127

SAD 09-07-14 ① CPO 09-07-15

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

PD 09-07-20

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

=> S 09/07/21

④ φ

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

0.00



Powdercoat

Memo

0.00

Powder Coating

1st COAT: START TIME:

9:30

OVEN TEMPERATURE:

FINISH TIME:

10:00

\*\*\*\*\*

2nd coat if necessary\*\*\*\*\* 2ND COAT: START TIME: \_\_\_\_\_ OVEN TEMPERATURE: \_\_\_\_\_

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

150

Identify as per dwg & Stock Location: \_\_\_\_\_

0.00



Packaging

Memo

0.00

Packaging

MK2148

0907-220

MK 09/07/22 (K)

7847824 9/1/24 (1) SN

# Work Order ID 47824B

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Page 3

Item ID: D3327-041

Accept



Setup Start



Revision ID: B

Item Name: Basket Lid Assembly

Stop



Start Date: 15/07/2009 Start Qty: 1.00



Cust Item ID:

Required Date: 03/08/2009 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

09/07/24 J

u 52A27

# Picklist Print

June 26, 2009 8:17:59 AM

Page 1

Work Order ID: 47824B

Parent Item: D3327-041RevB

Parent Item Name: Basket Lid Assembly



Comments:

Start Date: 15/07/2009

Required Date: 03/08/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M4130NTS0.500W.035		Purchased	No			100	f	0.0000	15.2632			
 4130 Square tube .500 x .500 x .035w												
m109127												
 SAO 09-07-14												

Qty	PART #	DESCRIPTION	BATCH
2	D3328-1	HINGE PLATE	<u>B33871</u> Pl 09.07.15
2	D3349-1	Spacer Bushing	<u>B34205</u> Pl 09.07.15
1	D3352-1	label Plate	<u>B41925</u> Pl 09.07.15
2	D3367-1	mounting BRACKET	<u>B43228</u> Pl 09.07.15

Bom updated  
by David Dural  
H

PARTS NOT SCANNED

Boms to be  
updated

Date: Friday, 08/05/2009 1:05:00 PM  
 User: Melanie Fauteux

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : BASKET LID ASSEMBLY
<b>Job Number</b> : 47824B	
<b>Estimate Number</b> : 11332	
<b>P.O. Number</b> :	<b>Part Number</b> : D3327041
<b>This Issue</b> : 08/05/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D3327 REV B
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : / / <b>Type</b> : LARGE FAB ASSY	<b>Drawing Revision</b> : B
<b>Previous Run</b> : 32863B	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 15/05/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : <u>MF 09-05-08</u>	
<b>Comment</b> : Est A 05.02.09 New issue KJ/JLM Est Rev:B 08-12-16 attach DEO DD verified by:EC	

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
----------------	------------------------------	----------------------

1.0	✓ M4130NTS0500W035	4130 Square tube .500 x .500 x .035w
-----	--------------------	--------------------------------------



**Comment:** Qty.: 15.2250 f(s)/Unit Total : 15.2250 f(s)  
 Material: 4130 Cond. N Square tube per MIL-T-6736,  
 1/2" x 0.035" wall  
 M4130N-TS0.500W.035)

M109127 SMD 09-07-14

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
-----	-------------	------------------------------



**Comment:** LARGE FABRICATION RESOURCE 1  
 1-Cut tubes as per Dwg D3327

Qty	Part Number	Description	Batch
2	D3328-1	Hinge Plate	B33871
2	D3349-1	Spacer Bushing	B34205
1	D3352-1	Label Plate	B41925
2	D3367-1	Mounting Bracket	B43228

~~B40775~~

Identify parts appropriately

2-Remove all markings from material and deburr as required .  
 Check for foreign objects.

3-Drill and Weld as per Dwg D3327 & QSI 004  
 A/RN/A Steel Rod M100075

4-Deburr as required

Cpl 09.07.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

Date: Friday, 08/05/2009 1:05:01 PM  
User: Melanie Fauteux

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET LID ASSEMBLY

Job Number: 47824B

Part Number: D3327041

Job Number:



Seq. #:

Machine Or Operation:

Description :

3.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-07-20

4.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Sofia/21 (X)

5.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M112148.

1ST COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

\*\*\*\*\* 2nd coat if necessary \*\*\*\*\*

2ND COAT:

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

PR 09-07-22 (X)

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Mch 09/07/22 (X)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

8.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

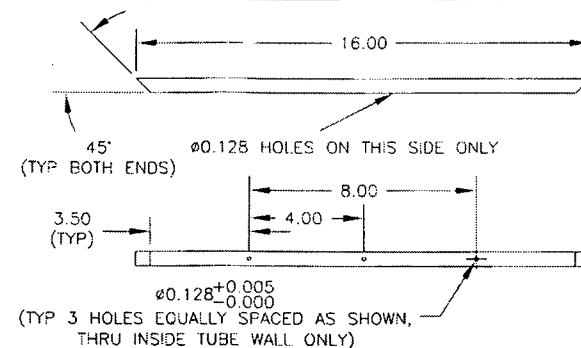
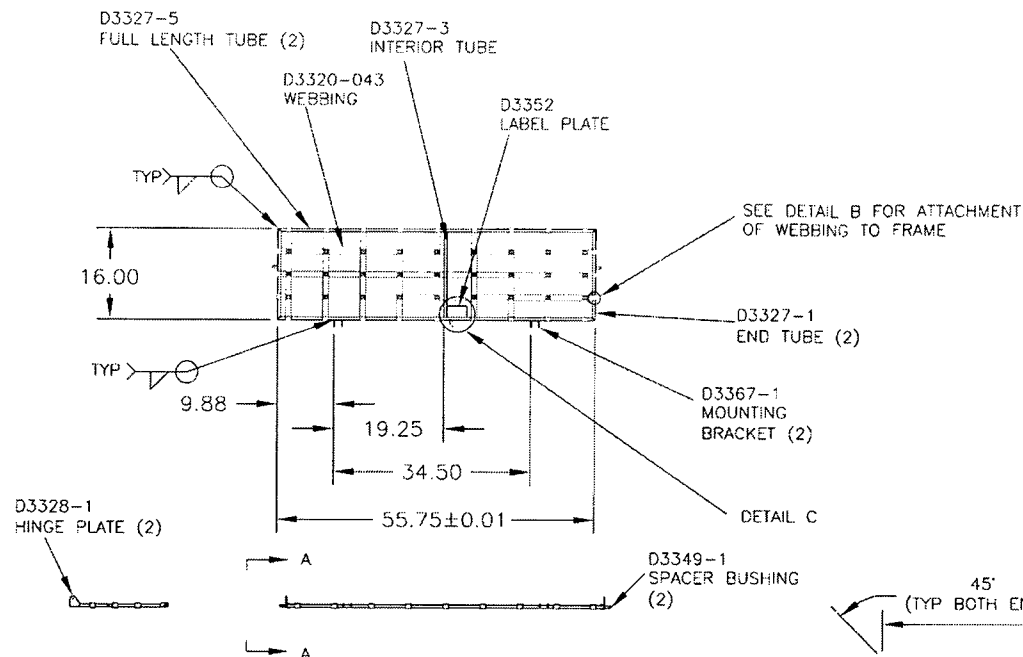
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

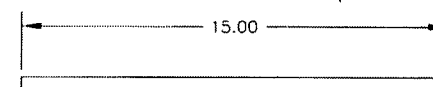
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

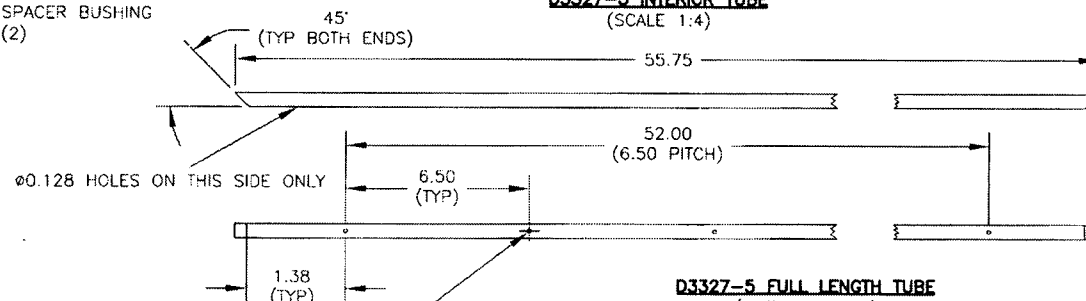




**D3327-1 END TUBE**  
(SCALE 1:4)



**D3327-3 INTERIOR TUBE**  
(SCALE 1:4)



**D3327-5 FULL LENGTH TUBE**  
(NOT TO SCALE)

# **D3327-041 BASKET LID ASSEMBLY**

- 1) FINISH: POWDER COAT ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3 (PRIOR TO INSTALLATION OF D3320-043)
- 2) WELD PER DART QSI 004
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

## **PARTS LIST FOR D3327-041 BASKET LID ASSEMBLY**

Part No.	Quantity	Description
D2729-1	1	PART ID LABEL
D3320-043	1	WEBBING
D3327-1	2	END TUBE
D3327-3	1	INTERIOR TUBE
D3327-5	2	FULL LENGTH TUBE
D3328-1	2	HINGE PLATE
D3349-1	2	SPACER BUSHING
D3351-1	1	PLACARD
D3352-1	1	LABEL PLATE
D3367-1	2	MOUNTING BRACKET
MS20606AD4W3	24	RIVET
AN950JD9	24	WASHER

#47824B

DEO ATTACHED

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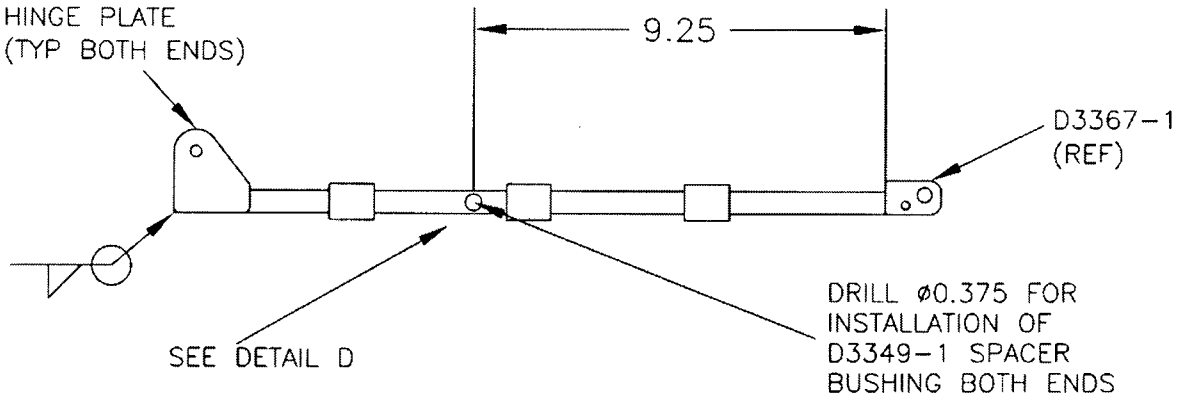
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B	05.04.25	CHANGE RIVET AND HOLE DIAMETER
A	04.10.21	NEW ISSUE
DESIGN	DH	DART AEROSPACE LTD. WARRICKSURY, ONTARIO, CANADA
CHECKED	CH	DRAWING NO. D3327
APPROVED	TH	REV B
DATE	05.04.25	SHEET 1 OF 3
		SCALE 1:20
		TITLE BASKET LID ASSEMBLY

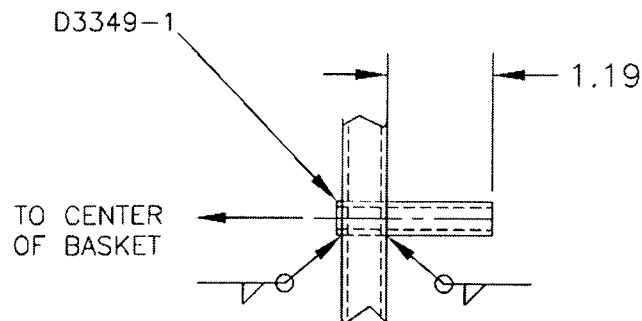


DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D3327	REV. B SHEET 2 OF 3
DATE 05.04.25	TITLE BASKET LID ASSEMBLY		SCALE 1:4

D3328-1  
HINGE PLATE  
(TYP BOTH ENDS)



VIEW A-A



DETAIL D  
(SCALE 1:2)

478248  
**DEO ATTACHED**

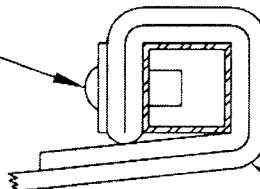
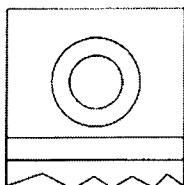
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DESIGN PH	DRAWN BY PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED PH	DRAWING NO. D3327	REV. B SHEET 3 OF 3
DATE 05.04.25		TITLE BASKET LID ASSEMBLY	SCALE 1:4

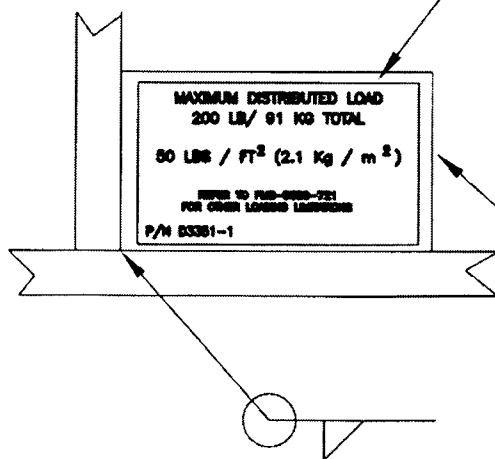
MS20600AD4W3 RIVET (1)  
AN960JD9 WASHER (1)



DETAIL B  
TYP. ATTACHMENT OF WEBBING TO LID  
FRAME  
(SCALE 1:1)

D3320-043 WEBBING

ATTACH D3351-1 PLACARD  
ON TOPSIDE OF D3352-1



D3352-1

DEO ATTACHED

#478248

OUTBOARD

IDENTIFY WITH DART P/N  
D350-721-043 USING  
D2729-1 PRODUCT ID LABEL  
INSTALLED ON UNDERSIDE OF  
D3352-1

DETAIL C  
LABEL PLATE ATTACHMENT  
(SCALE 1:2)

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DRAWING NO. D3327	TITLE BASKET LID ASSEMBLY	REV. B	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3327-B-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED <i>[Signature]</i>	MFG. APPR. <i>[Signature]</i>	APPROVED <i>[Signature]</i>		DE APPR. <i>[Signature]</i>		
DATE 08.11.28	DATE 08.11.28	DATE 08.12.01	DATE 08.12.01		DATE 08.12.01		

1) SHEET 1 MODIFY PARTS LIST AS SHOWN:

**PART LIST FOR D3327-041 BASKET LID ASSEMBLY**

Part No.	Quantity	Description

**IS:**

MS20600AD4W5	24	RIVET
--------------	----	-------

**WAS:**

MS20600AD4W3	24	RIVET
--------------	----	-------

2) UPDATE SHEET 3 DETAIL B ACCORDINGLY.

#47824B